

**\*121354\***

Page 1

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 6/25/14      **Start Qty:** 16.00

**\*16\***

**Cust Item ID:**

**Required Date:** 6/26/14      **Req'd Qty:** 16.00

**\*16\***

**Customer:**

**Reference:**

**Approvals:**

### Process Plan:

Date:

**Tooling:**

**Date:**

Run Start \*NR1\*

**QC:**

Date:

**SPC (Y/N):****Date:**

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>*110*</b> Packaging	Pick Kit	0.00							DAS 41 9-89
<b>*110*</b> Packaging	Memo	0.00				16	Ø	Ø	14-7-22
<b>*120*</b> Small Fab		0.00							DAS 41 9-89
<b>*120*</b> Small Fab	Memo	0.00				16	Ø	Ø	14-7-22
	Assemble as per dwg and apply loctite 598 on all faying surfaces per note 2.								
	A/R RTV LOCTITE 598:	125540							
	exp. date:	5/15							
<b>*130*</b> QC <sub>q</sub>	QC5- Inspect part completeness to step on W/O	0.00							DAS 27 9-89
<b>*130*</b> Quality Control	Memo	0.00				16			14/7/24



# Picklist Print

June-25-14 12:47:04 PM

Page 1

Work Order ID: 121354

**\*121354\***

Parent Item: 647.9701

**\*647 9701\***

Parent Item Name: Lower Cutter Sub Assembly

Start Date: 6/25/14

Required Date: 6/26/14

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A NEW ISSUE 13-03-21 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.9710 <b>*647 9710*</b> Lower Body		Purchased	No	91439 98918			Each	0.0000	**	② 16 14	DAS 41 9-89	14-7-22	
MS27039-08-19 <b>*MS27039-08-19*</b> Screw		Purchased	No				Each	1,684.000	**	9648	DAS 41 9-89	14-7-22	

## Location

## Loc Qty

## Loc Code

ST506

1684

124309

282

125654

127

m127410

275

m127904

1000

NAS1149FN832P

Purchased

No

Each

8,491.000

\*\*

**\*NAS1149FN832P\***

Washer

DAS  
41  
9-89

14-7-22

## Location

## Loc Qty

## Loc Code

ST275

8491

123185

30

123522

400

125268

8061

192

# Picklist Print

June-25-14 12:47:04 PM

Page 2

Work Order ID: 121354

Parent Item: 647.9701

Parent Item Name: Lower Cutter Sub Assembly

**\*121354\***

**\*647 9701\***

Start Date: 6/25/14

Required Date: 6/26/14

Start Qty: 16.00

Required Qty: 16.00

MS21042L08

Purchased

No

Each

4,930.000

48 96

DAS

41

9-89

14-7-22

**\*MS21042L 08\***

Nut

\*\*

## Location

## Loc Qty

## Loc Code

ST306

4930

123900

58

125445

265

m127304

99

m127410

1398

m128401

1500

m128429

1410

m129541

200

96

646.9711

Manufactured

No

Each

327.0000

32

DAS

41

9-89

14-7-22

**\*646 9711\***

Blade

\*\*

## Location

## Loc Qty

## Loc Code

CA

327

100268

72

102756

18

104205

25

104935

24

106350

15

108731

31

109392

21

10041

60

110622

15

112223

20

115250

8

90824

1

98911

17

32 32 32

June-25-14 12:47:04 PM

Shop Packet Print

Page 2

# APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO.

03933

SHEET 1 OF 1

DWG NO. 647.9700

REV: A

PREPARED BY B. PETERS

DATE: 06/14/13

EFFECT ON DWG  
☐ INC. ☒ UNINC.

DWG TITLE: CUTTER SUB ASSYS

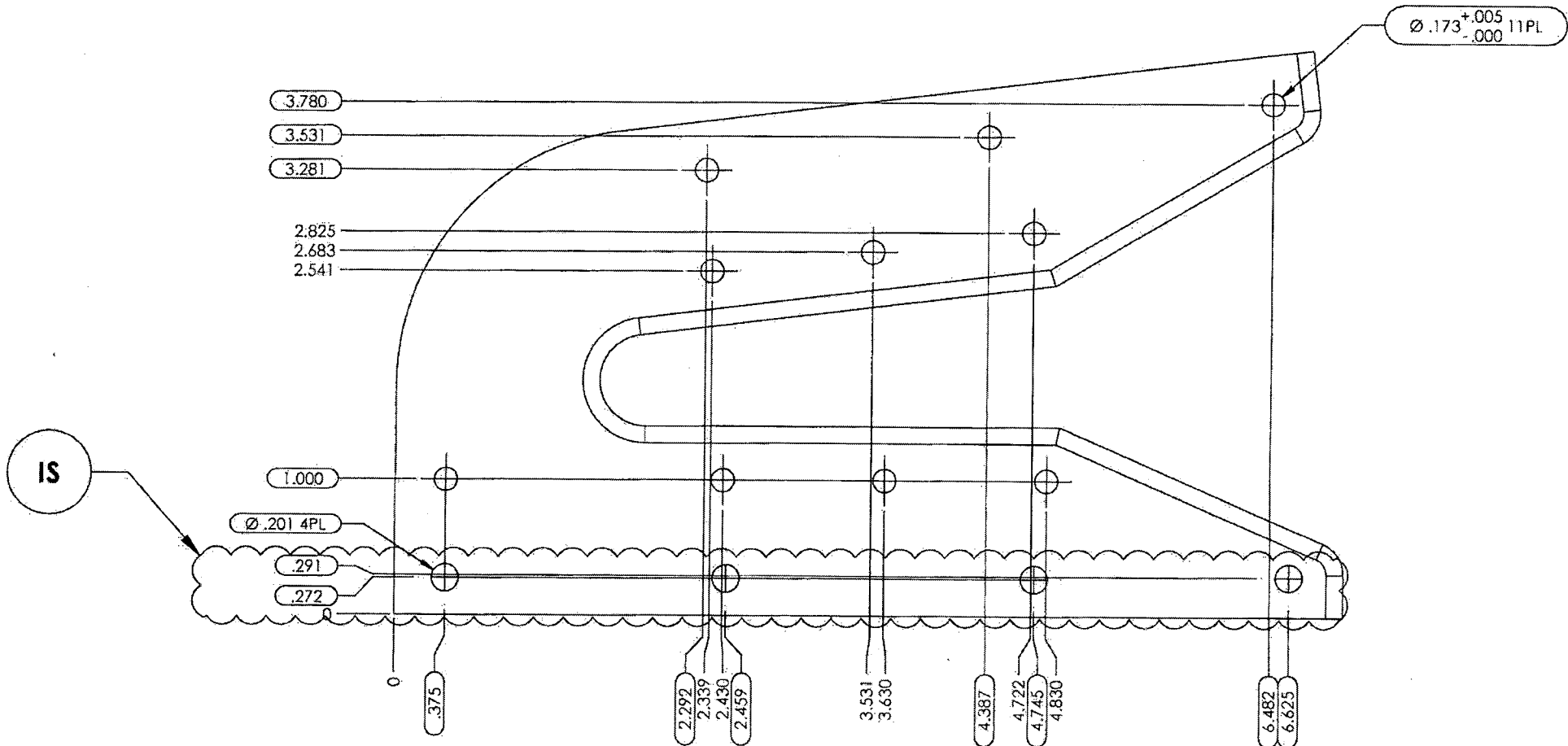
APPROVED BY: ENGR *[Signature]*

MFG *[Signature]* QC *[Signature]*

EFF. CURRENT ORDER

TRANSACTION CODES (TC):  
A-ADD C-CREATE  
R-REVISE D-DELETE

REASON: CORRECTED DIMENSIONAL ERROR.



**SHEET 7, ZONE C1 IS:**

DOCUMENTS EFFECTED:

☐ MDL ☐ INSTALL INSTRUCTIONS ☐ ICA ☐ FMS ☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES ☒ NO

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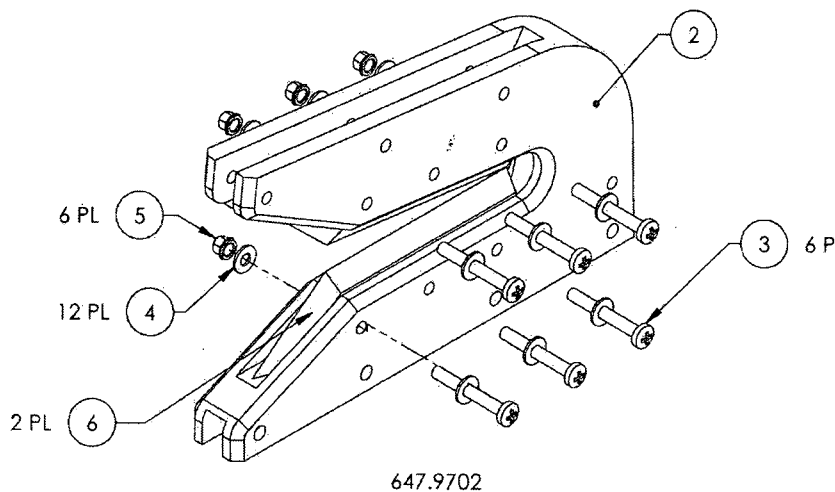
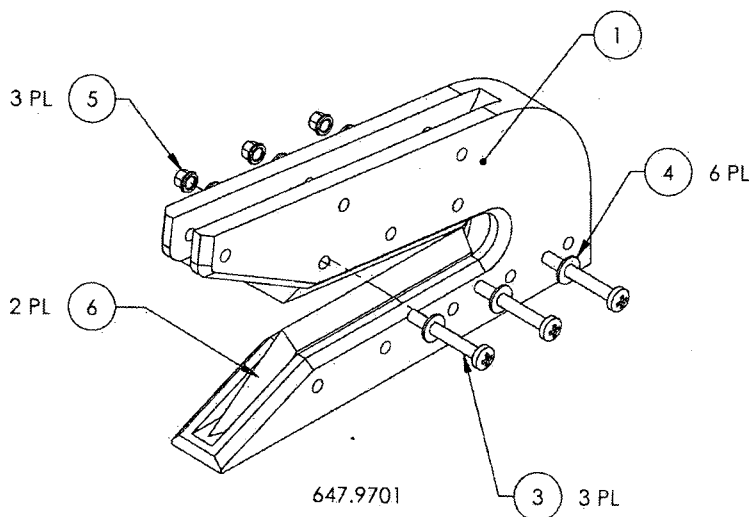
# NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;  
PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER;  
PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX.
4. DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED.
5. IDENTIFY IAW MPP-120.
- 6 APPLY F/N 7 AS REQUIRED TO ALL FAYING SURFACES OF F/N 6 UPON ASSEMBLY.
- 7 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE.
- 8 DIMENSION SHOWN IS FOR INSPECTION AFTER FINISH.

UNINCORPORATED ECN(S)

03933

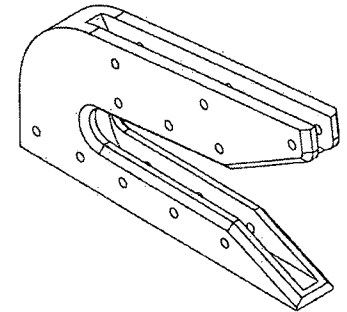
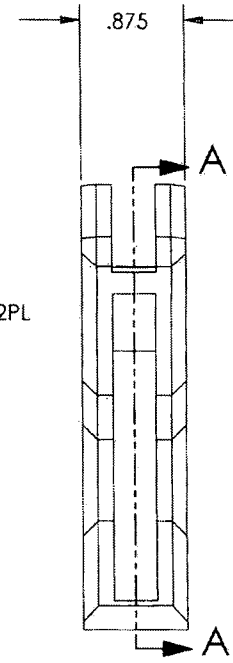
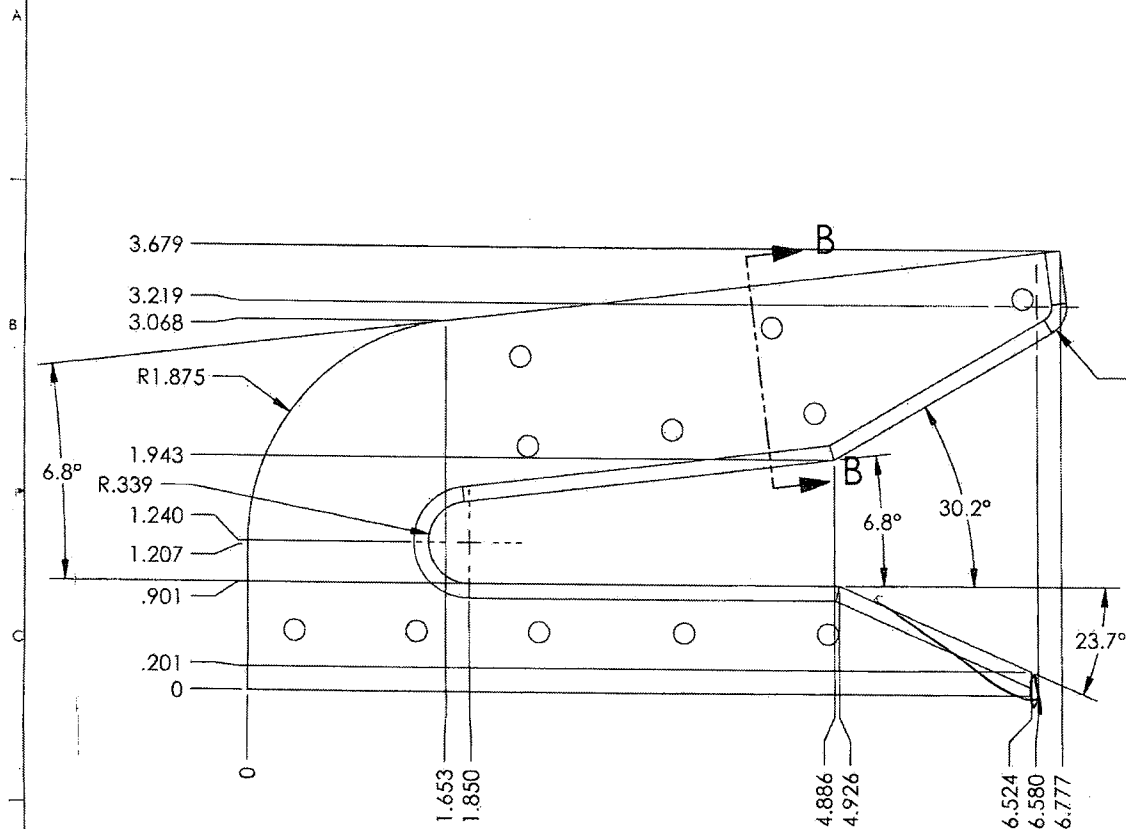
REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
1	LAST PRODUCTION RELEASE PRT		
2	INITIAL RELEASE	04-26-10	P. BRAND
3	UNINCORPORATED ECN 03933 & 03934	04-11-10	P. BRAND



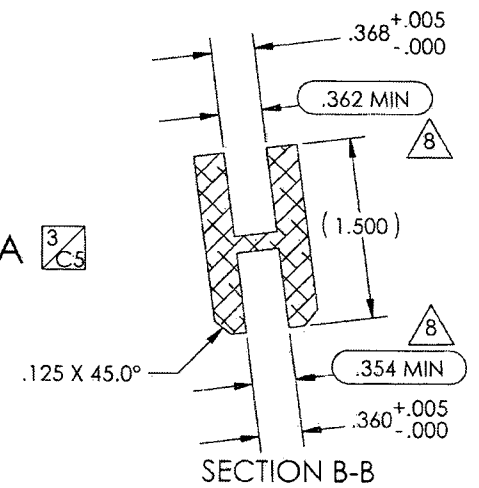
A/R	A/R	7	601.2764	RTV	LOC:11E 59B	
2	2	6	646.9711	BLADE		
6	3	5	601.1541	LOCKNUT	MS21042LOB	
12	6	4	601.2764	WASHER	NAS1149FN832P	
6	3	3	601.2765	SCREW	MS27039-0819	
1		2	647.9711	UPPER BODY		
	1	1	647.9710	LOWER BODY		
			647.9702	UPPER CUTTER ASSY		
			647.9701	LOWER CUTTER ASSY		
.9702	.9701	FIND #	PART #	DESCRIPTION	MATL	SPEC.

QTY	DESCRIPTION	DATE	APPROVED
NEXT ASSY (S)	647.9200	04-26-10	P. BRAND
APICAL INDUSTRIES			
2608 TEMPLE HEIGHTS DR.			
OCEANSIDE, CA. 92056-3512 (760) 724-5300			
CUTTER SUB ASSYS			
DATE: 04-26-10	REV: A	DWG NO: 647.9700	SHEET 1 OF 7
SCALE: NONE			

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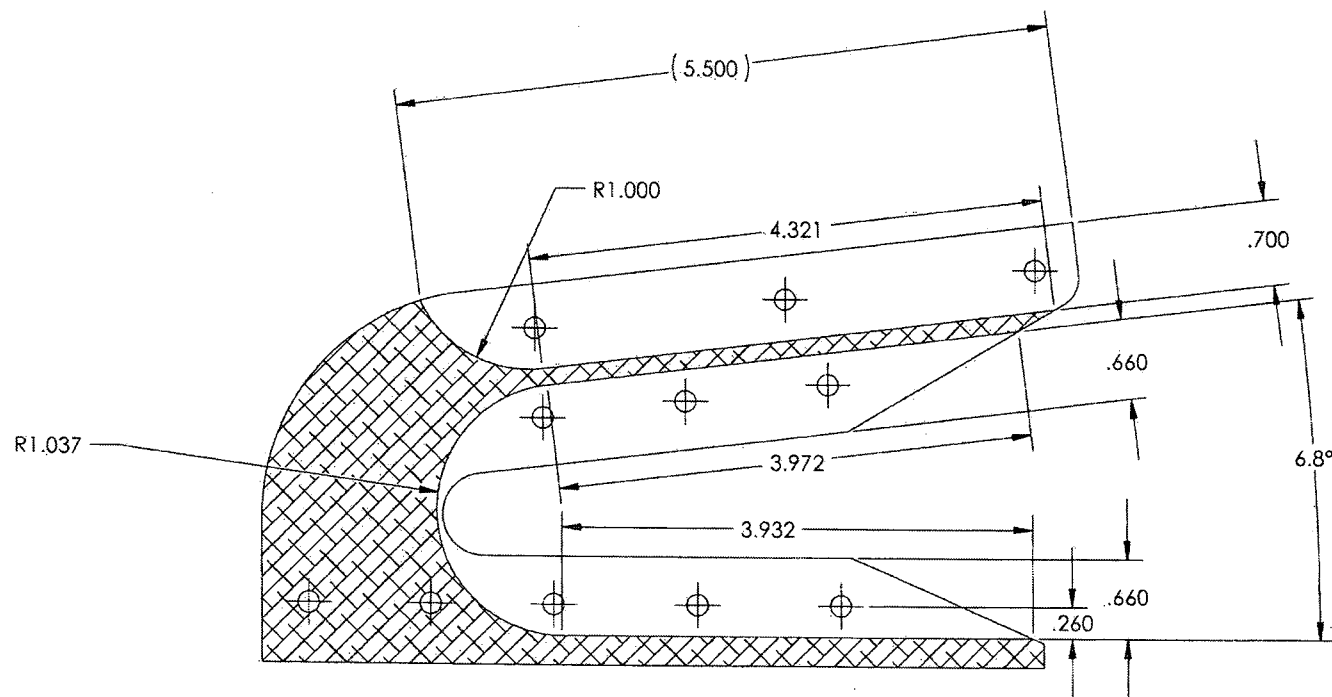


647.9710



ORIGINAL DATE (DATE) OF: 04-24-00 DRAWN BY: A. DIAZ CHECKED BY: P. BRAVO DRAWING APPROVAL: DATE: 05-01-00 CONTRACT NO:		<b>APICAL INDUSTRIES</b> 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.003 2 PLACE DECIMALS ±.005 1 PLACE DECIMALS ±.010 1/16" ±.0031		SIZE: 07M76 CAGE CODE: 647.9700 SCALE: NONE	REV. A: SHEET 2 OF 7

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SECTION A-A

2/B6

ORIGINAL DATE 04/24/00		APICAL INDUSTRIES	
DRAWN BY: A. OLIVIA		2608 TEMPLE HEIGHTS DR.	
CHECKED BY: P. BRAVO		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL BY: BRAVO		CUTTER SUB ASSYS	
DATE: 04/24/00		SCALE: NONE	
DIMENSIONS SPECIFIED: DIMENSIONS ARE IN INCHES		SHEET 3 OF 7	
TOLERANCES: .015		REV: A	
2 PLACE DECIMALS ± .01		DNG NO: 647.9700	
3 PLACE DECIMALS ± .001		CAGE CODE: 07M76	
ANGLES: ± .5°		SHEET 3 OF 7	



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A

B

C

D

3.279

3.030

2.780

2.327

2.185

2.042

$\phi .177^{+.005}_{-.000}$  11PL

.501

0

0

.390

1.410

2.272

2.339

2.430

3.531

3.630

4.367

4.722

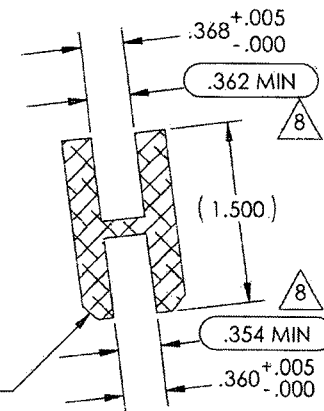
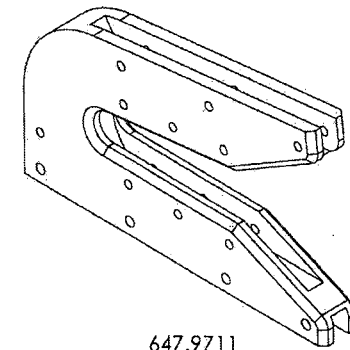
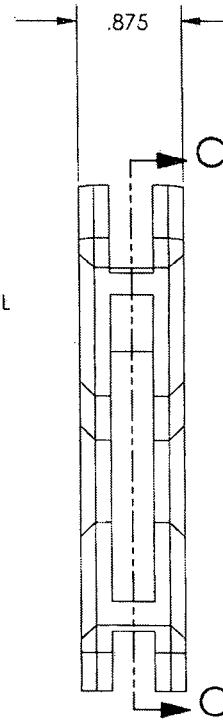
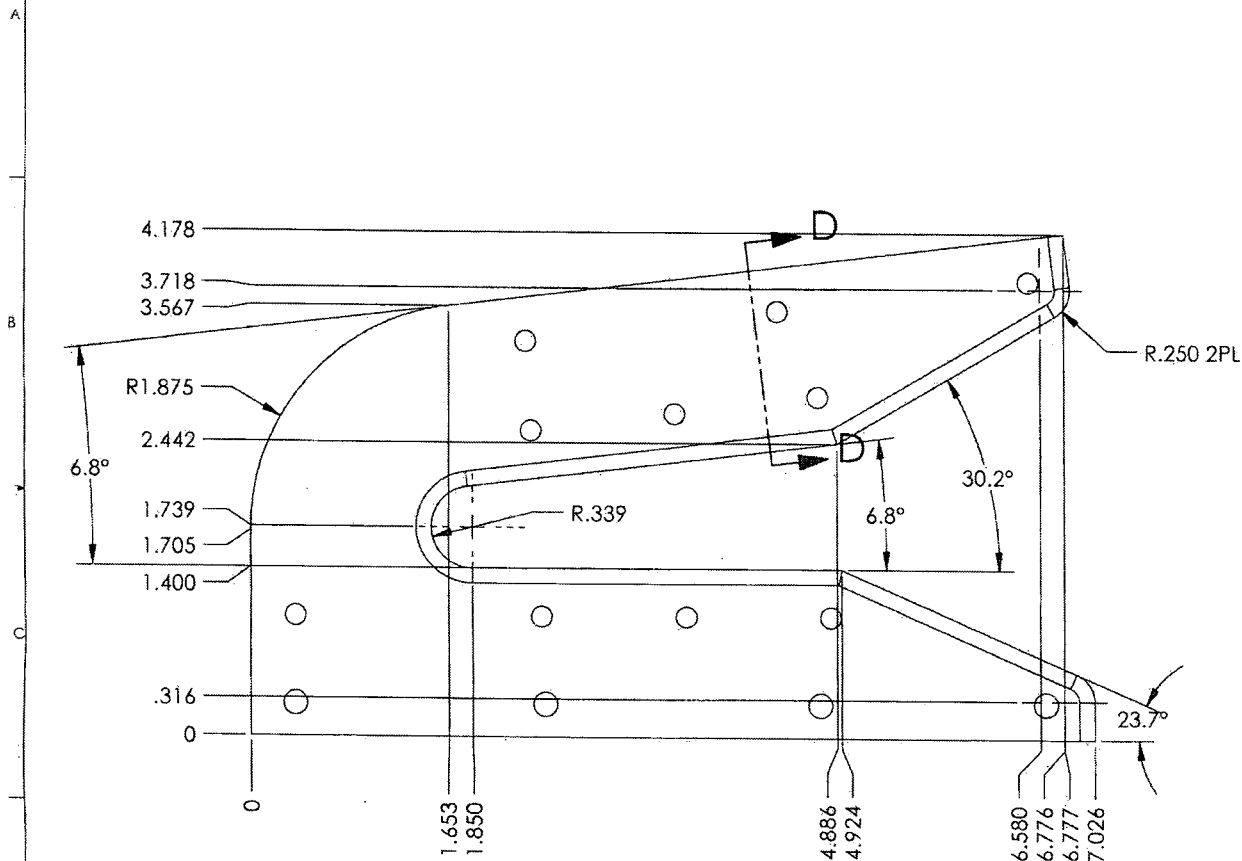
4.830

6.462

HOLE LOCATIONS +/- .002

ORIGINAL DATE 11/02/2010		APICAL INDUSTRIES	
DRAWN BY A. GUAN		2608 TEMPLE HEIGHTS DR.	
CHECKED BY P. BRAYO		OCEANSIDE, CA. 92056-3512 (760) 724-5300	
DRAWING APPROVAL P. BRAYO		CUTTER SUB ASSYS	
SCALE: NONE		SHEET 4 OF 7	
1/16" (1/16" OTHER W/ 1/16" SPECIFIED) DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS .005 3 PLACE DECIMALS .000 ANGLES .5°		SIZE CAGE CODE B 07M26	DWG NO 647.9700
		REV A	REV A

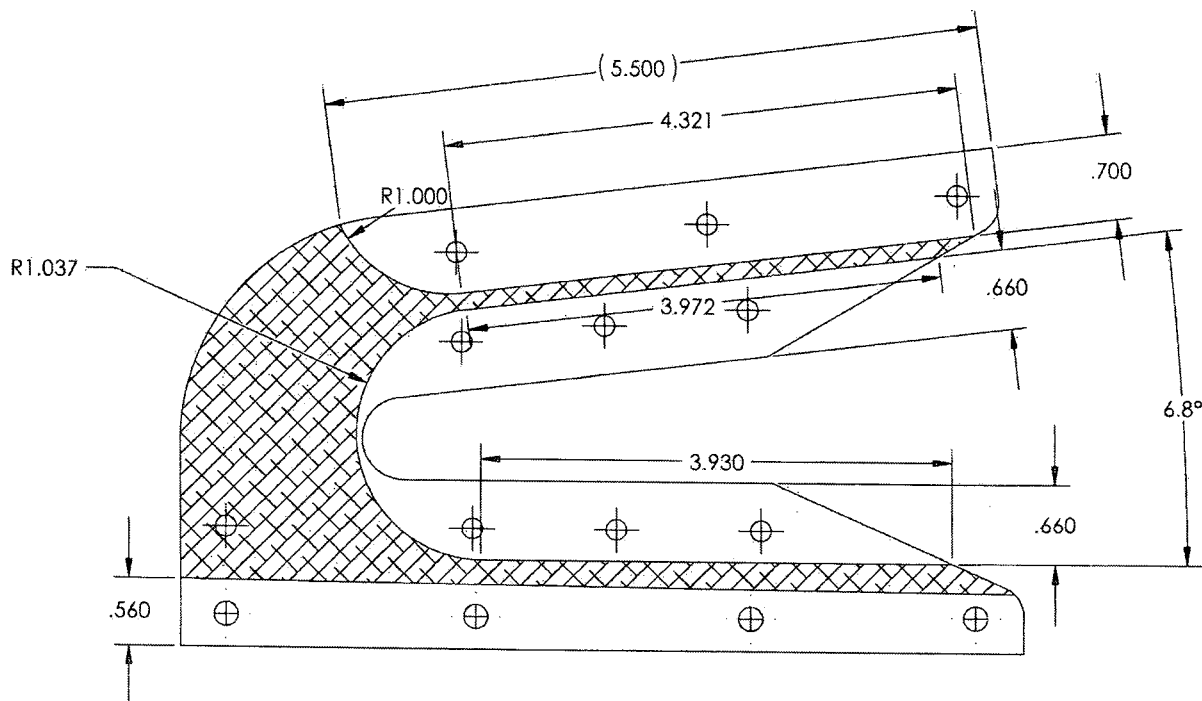
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SECTION D-D

ORIGINAL DATE P/D (S.A. YR) 04-24-19		APICAL INDUSTRIES	
DRAWN BY: CHICKEN		2608 TEMPLE HEIGHTS DR.	
C. GRANT P. BRADY		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL		CUTTER SUB ASSYS	
P. BRADY		SIZE: CAGE CODE: 07M26	
P/D (S.A. YR) 04-24-19		Dwg. No. 647.9700	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.03 3 PLACE DECIMALS ±.010 ANGLES ±.2°		SCALE: NONE	
		SHEET 5 OF 7	

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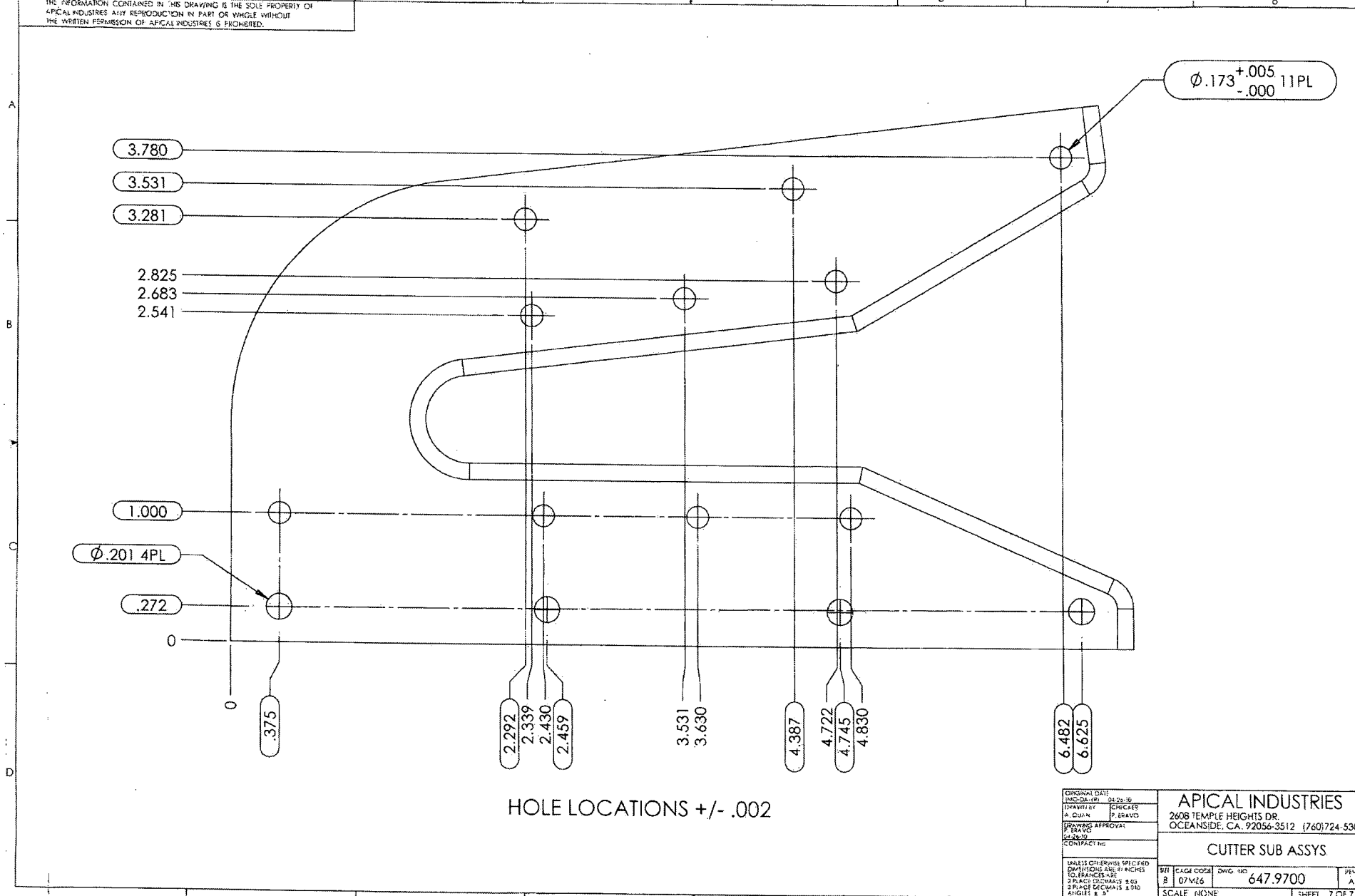


SECTION C-C 5  
B6

*u/b  
120354*

ORIGINAL DATE 1/10/04 YR 04-06-10		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY A. OLSON	CHECKED P. BRAYO	CUTTER SUB ASSYS	
DRAWING APPROVAL P. BRAYO		SIZE B	REV. A
TECHNIPACT NO.		CAGE CODE 07M26	QNG. NO. 647.9700
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ±.00 2 PLACE DECIMALS ±.010 ANGLES ±.5°		SCALE NONE	SHEET 6 OF 7

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ORIGINAL DATE: 04-29-10		APICAL INDUSTRIES	
DRAWN BY: CHICKER		2608 TEMPLE HEIGHTS DR.	
A. GUINN		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAT: P. BRAVO		CUTTER SUB ASSYS	
SCALE: 1/4" = 1"			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TO 3 DECIMALS		SHEET: 647.9700	REV: A
SCALE: NONE		SHEET: 7 OF 7	